

013303



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

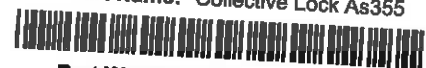
D3400-041
Job Sheet 202605



Part No: D3400-041

Job Qty: 1 pcs

Part Name: Collective Lock As355



Part Weight: 0 lbs

Job Created: 10/31/19

Due Date: 12/6/19

Type: SOLD

Note: DWG D3400 REV.A IPP Rev:A new issue DD 10.04.15 verified by:EC

Ship Via:

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
120	Small Fab - 1	1 pcs	12/6/19	12/6/19	0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		DEC 09 2019
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
150	QC 5	1 pcs	12/6/19	12/6/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		EL
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
154	Large Fab - Welded Assy-2-B4B	1 pcs	12/6/19	12/6/19	0.00	0.25	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		EL
							Large Fab - 2 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S238153



Part: D3400-041

Job No: 202605

Serial No/Batch: S238153

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/09/19

				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
				156 QC 9	1 pcs
QC 9 - 18					
QC 9 - 24					
QC 9 - 43					
QC 9 - 50					
QC 9 - 9					
160 Packaging 3-1 - Stock - B4B	1 pcs	12/6/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1 pcs	12/6/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
24
9-50

DEC 09 2019

DAS
21
9-50

DEC 17 2019

Part Op 120 - 1- Press fit dowel pin in D3400-5 2-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock
Descriptions: barrel. Discard the rest. 3-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 4-Assemble D3400-053 as per
Dwg D3400. Apply a drop of permanent lockite 262 to the threads A/R Lockite 262 Batch: S157322 5-Assemble
D3400-051 as per Dwg
150 - (QC5- Inspect part completeness to step on W/O)

cap 07 01/2020

DAS
24
9-99

DEC 09 2019

DEC 17 2019

ST123

SIS 1322
exp 07/01/2020

Part Op 120 - 1- Press fit dowel pin in D3400-5 2-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock
Descriptions: barrel. Discard the rest. 3-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 4-Assemble D3400-053 as per
Dwg D3400. Apply a drop of permanent locktite 262 to the threads A/R Locktite 262 Batch: 5-Assemble
D3400-051 as per Dwg
150 - (QC5- Inspect part completeness to step on W/O)

- 154 - Tack weld lock shaft as per Dwg D3400 A/R SS Rod Batch: _____
- 156 - QC9- Inspect visual per QSI004- Fusion Welds
- 160 - (Identify as per dwg & Stock Location: _____)
- 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
238-028	3/16" Dowel Pin .5" long	2 Ea (2 ea)	120-Small Fab - 1	ALL 132062
5/16WC	Washer	2 Ea (2 ea)	120-Small Fab - 1	S220304
D3369-5	Spacer	1 pcs (1 ea)	120-Small Fab - 1	F132594 S 210404
D3372-5	Cam Lock Shaft	1 pcs (1 ea)	120-Small Fab - 1	S208526
D3373-1	Cam Lock	1 pcs (1 ea)	120-Small Fab - 1	S204947
D3384-043	Cyclic Sock Assembly	1 pcs (1 ea)	120-Small Fab - 1	F16248
D3400-1	Main Body	1 pcs (1 ea)	120-Small Fab - 1	R22562 S0 86937
D3400-3	Guide	2 pcs (2 ea)	120-Small Fab - 1	S237514
D3400-5	Slider Body	1 pcs (1 ea)	120-Small Fab - 1	R22562 S0 86938
HX-81	1/4"-20 SHCS 3/8" long	1 Ea (1 ea)	120-Small Fab - 1	S212160
NAS1149F0463P	Washer (AN960-416)	2 Ea (2 ea)	120-Small Fab - 1	S201001

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	238-028	2	111	0
	5/16WC	2	1,670	0
	D3369-5	1	11	0
	D3372-5	1	5	0
	D3373-1	1	21	0
	D3384-043	1	5	0
	D3400-1	1	7	0
	D3400-3	2	0	0
	D3400-5	1	7	0
	HX-81	1	35	0
	NAS1149F0463P	2	348	0

Part Specifications

Specifications could not be found.



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:	QTY Affected :		MRB (QS1042)							
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐							
								Completed By			
								Lead hand / Supervisor			
								QC / QA Coordinator			